

DART SERVICE INSTRUCTION

SUPPLEMENTAL TO INSTALLATION INSTRUCTIONS IIN-D412-698 REV. E &

INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-698 REV. 5

(REF. TCCA STC SH92-43, FAA STC SR01446NY & EASA STC EASA.IM.R.S.00709)

PURPOSE

THE PURPOSE OF THE D412-698-025 KIT IS TO ALLOW OPERATORS THAT HAVE PERFORMED THE BELL/AUGUSTA SERVICE INSTRUCTION TA212-138/2-22B TO THE LH/RH CABIN DOORS TO REPLACE THE EXISTING P/N 205-031-435-001 & 205-031-435-002 ROLLERS WITH DART P/N D3121-143 & D3121-144 ROLLERS. THIS KIT ALSO REPLACES THE EXISTING DOOR TRACK WITH SEGMENTED "J" BRACKETS DART P/N D3675-3 (SEE FIGURE 3 FOR THE LOCATION OF BOTH CHANGES).

THERE IS A NEGLIGIBLE WEIGHT CHANGE ASSOCIATED WITH THIS MODIFICATION.

PROCEDURE

- 1.) REMOVE HINGE PANEL DOOR PER AIRCRAFT MAINTENANCE MANUAL.
- 2.) REMOVE BELL P/N 205-031-435-001 AND 205-031-435-002 ROLLERS. RETAIN HARDWARE IF AIRWORTHY.
- 3.) REMOVE THE BELL/AUGUSTA DOOR TRACK. RETAIN HARDWARE IF AIRWORTHY.
- 4.) INSTALL DART P/N D3121-143 & D3121-144 USING EXISTING HARDWARE AND SHIMS IF AIRWORTHY. REPLACE EXISTING BELL SHIMS IF NO LONGER AIRWORTHY WITH DART P/N D3238-3/13 AS REQUIRED (SEE FIGURE 1). TORQUE FASTENERS PER AIRCRAFT MAINTENANCE MANUAL.
- 5.) INSTALL THE DART P/N D3675-3 SLIDING DOOR BRACKETS ("J" BRACKETS) & THE D3202-5 COVER, PER FIGURE 2 USING EXISTING HARDWARE. TORQUE FASTENERS PER AIRCRAFT MAINTENANCE MANUAL.
- 6.) RE-INSTALL MODIFIED DOOR ON AIRCRAFT PER AIRCRAFT MAINTENANCE MANUAL.
- 7.) CHECK SLIDING OPERATION OF DOOR. ADJUST POSITION/SHIMMING OF ALL NEW BRACKETS UNTIL DOOR OPERATION IS SMOOTH AND FREE OF DRAGGING/BINDING THROUGH FULL TRAVEL OF DOOR. RE-TORQUE ALL FASTENERS PER AIRCRAFT MAINTENANCE MANUAL.

NOTE: ENSURE VERTICAL ROLLERS ARE SITTING FLUSH TO THE DOOR TRACKS TO PREVENT ROLLER WEAR AND PREMATURE DOOR TRACK WEAR.

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| CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01 | |
| APPROVED  BY: D. SHEPHERD (DE # 02) | |
| DATE: | 08.11.04 |
| CERT. NO.: | SH92-43 |
| ISSUE NO.: | 5 |

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|------------|--|---|--|-----|--------------|
| B | ADD D3202-5 & D3675-3 & (COVER & "J" BRACKETS) CUSTOMER REQUEST TO REPLACE BELL/AUGUSTA MOD PARTS. | | | AJS | 08.11.04 |
| A | NEW ISSUE | | | AJS | 08.07.02 |
| REV. | DESCRIPTION | | | BY | DATE |
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | | |
| DRAWN | AJS | | | | REV. B |
| CHECKED | | DRAWING NO. | | | |
| MFG. APPR. | N/A | DSI 9409 | | | SHEET 1 OF 5 |
| APPROVED | | TITLE | | | SCALE |
| DE APPR. | | HINGE PANEL ROLLER KIT | | | NTS |
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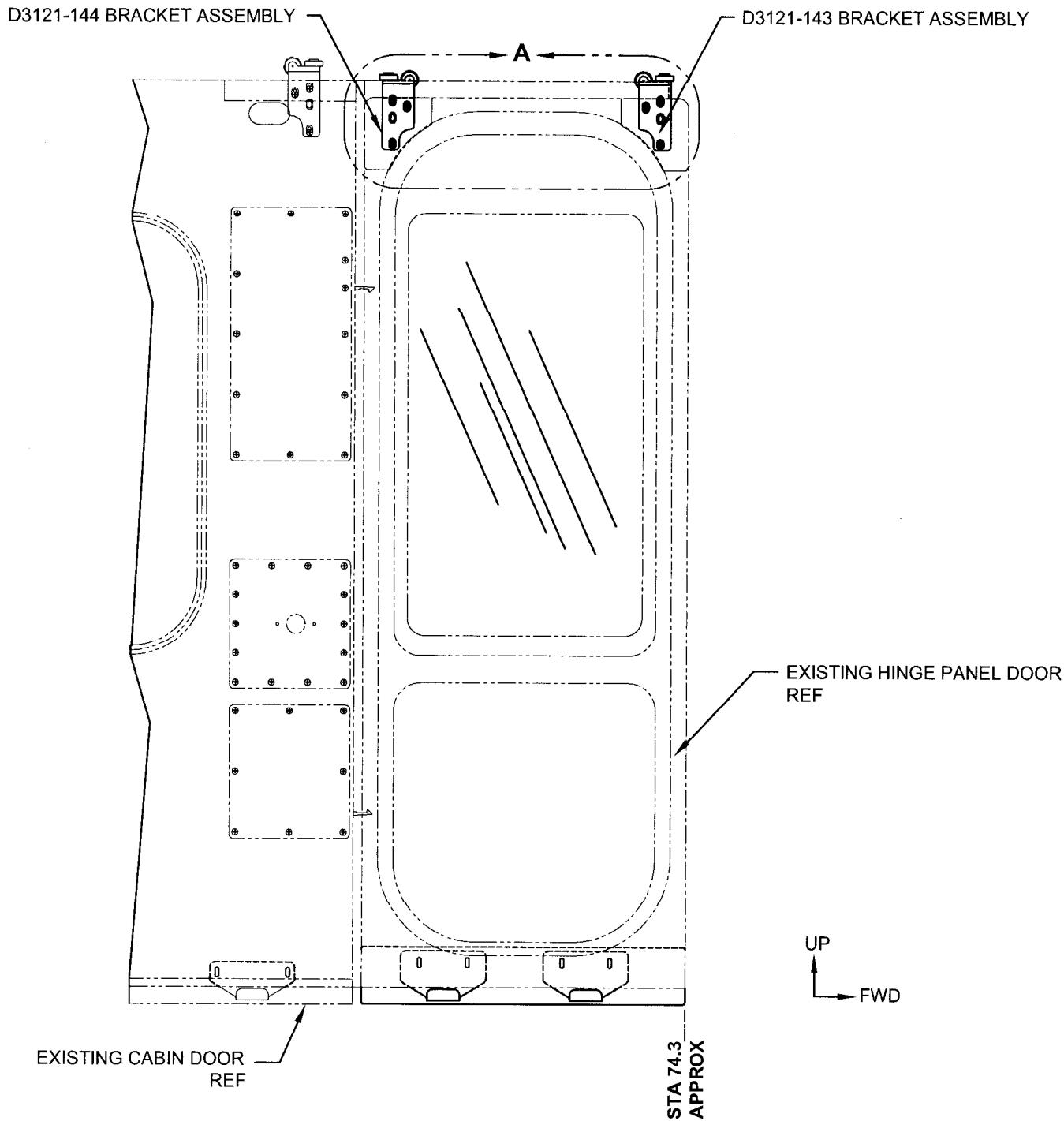


FIGURE 1. D412-698-025 HINGE PANEL DOOR ROLLER KIT
 (VIEW OF L/H HINGE PANEL DOOR LOOKING OUTBOARD, R/H DOOR OPPOSITE)

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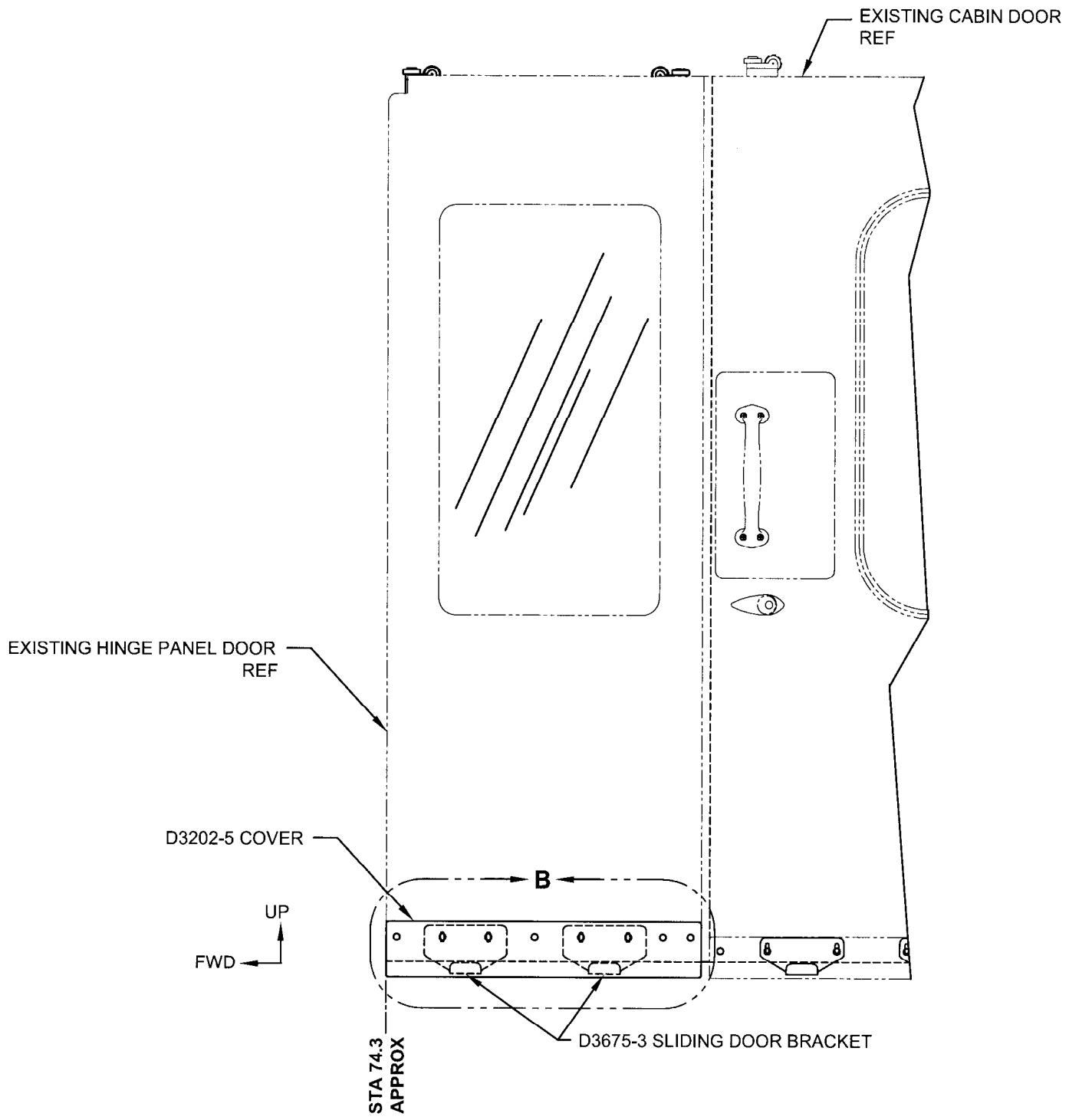
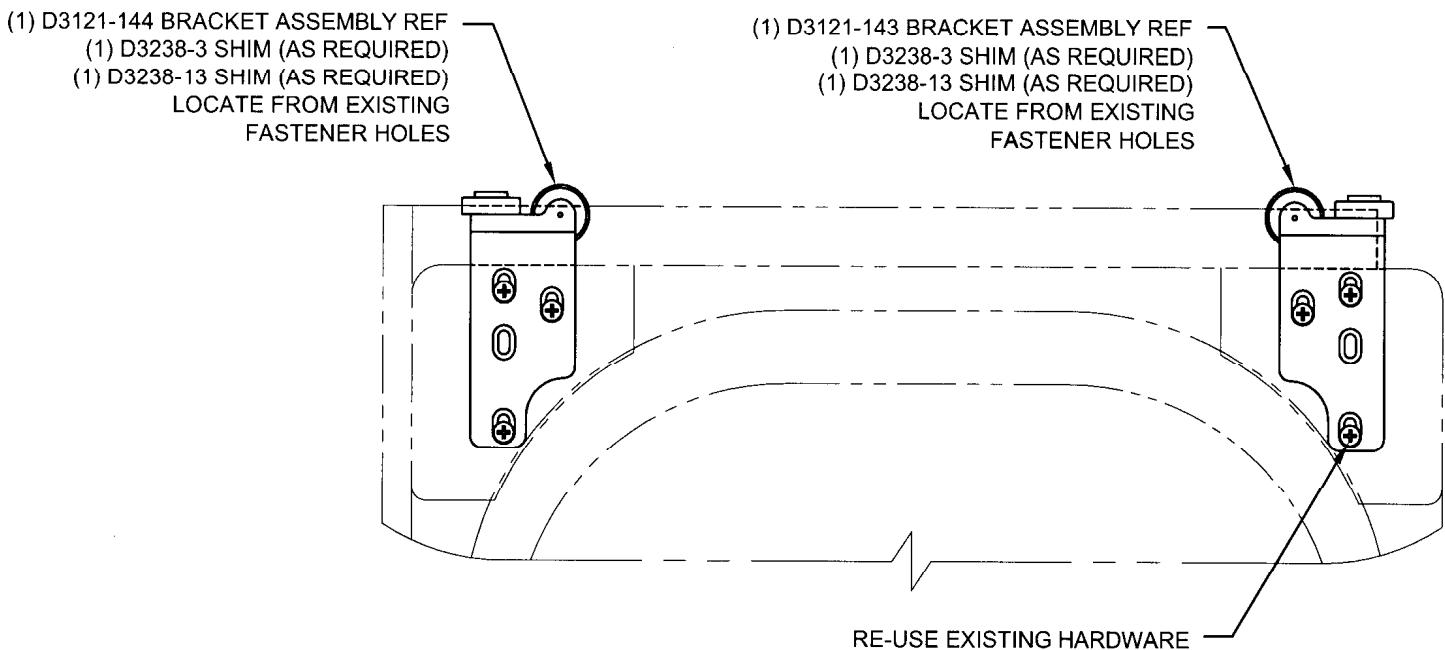


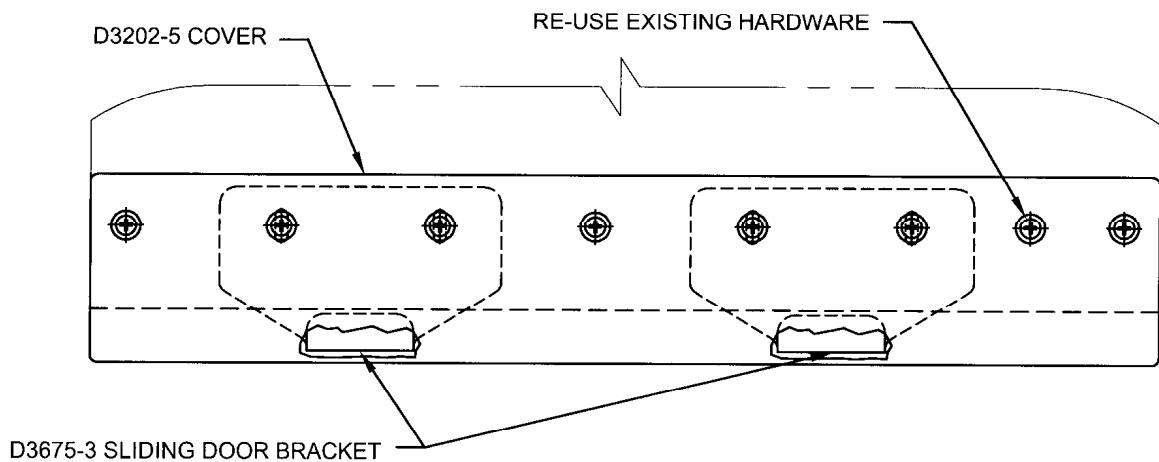
FIGURE 2. D412-698-025 HINGE PANEL DOOR ROLLER KIT
 (VIEW OF L/H HINGE PANEL DOOR LOOKING INBOARD, R/H DOOR OPPOSITE)

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| APPROVED <i>[Signature]</i> | D. SHEPHERD (DE # 02) |
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DETAIL A VIEW ON L/H HINGE PANEL DOOR (LOOKING OUTBOARD)
 (RH DOOR OPPOSITE)



DETAIL B VIEW ON L/H HINGE PANEL DOOR (LOOKING INBOARD)
 (RH DOOR OPPOSITE)

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| BRANCH | |
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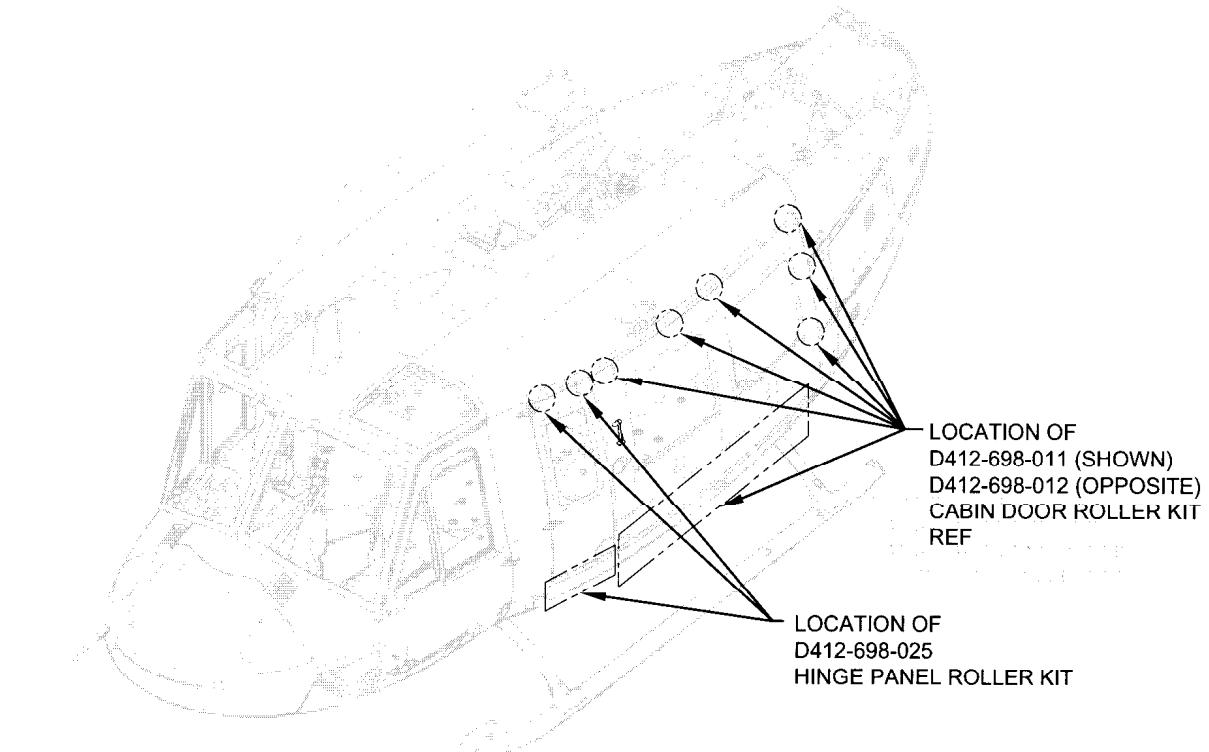


FIGURE 3. LOCATION OF D412-698-025 HINGE PANEL ROLLER KIT
(D412-698-011/-012 SHOWN FOR REFERENCE ONLY)

TABLE 1. PARTS LIST FOR D412-698-025

| QTY -025 | PART NUMBER | DESCRIPTION |
|-------------|-------------|--|
| X | PART NUMBER | HINGE PANEL DOOR ROLLER KIT (FITS L/H OR R/H DOOR) |
| 1 | D3121-143 | BRACKET ASSEMBLY |
| 1 | D3121-144 | BRACKET ASSEMBLY |
| 1 | D3202-5 | COVER |
| 2 | D3238-3 | SHIM |
| 4 | D3238-13 | SHIM |
| 2 | D3675-3 | SLIDING DOOR BRACKET |

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| MFG. APPR. | N/A | |
| APPROVED | <i>[initials]</i> | REV. B SHEET 5 OF 5 |
| DE APPR. | <i>[initials]</i> | |
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